

Date: Tuesday, 7/17/2007 2:00:51 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 33594	
Estimate Number : 11049	
P.O. Number : <i>N/A</i>	Part Number : D2847
This Issue : 7/17/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2847 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 29887	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 8/24/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>32</i> Um: <i>30</i> Each
Comment : Est F00.06.22 Removed P/O for powder coat EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0375X02000	6061-T6 Bar .375 x 2.0"
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Comment: Qty.: 0.1400 f(s)/Unit Total : 4.1990 f(s)

6061-T6 Bar .375 x 2.0"

Material: 6061-T6 or 6061-T651 Aluminum (QQ-A-255/8 or QQ-A-200/8 or QQ-A-250/11) 2.000" x 0.375"

Thick

Batch: *M19059*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 6.25"

Note: 1 Blank makes 4 parts

*SD 07.11.22*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2847

*SD 07.12.12*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SD 07.12.12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 01/12/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 33594

Part Number: D2847

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*Handwritten:* 07-12-14 (32)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

*Handwritten:* Tumble to remove rough edges  
Deburr any rough edges after tumbling  
Sink as per Dwg D2847

*Handwritten:* OK →

*Handwritten:* N/A

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* N/A

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*Handwritten:* 04-12-12 (32)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*Handwritten:* m105914

*Handwritten:* Fd 07/12/18 (32)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Handwritten:* 07-12-18 (32)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Handwritten:* 5149

*Handwritten:* 07/12/18 (32)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten:* 07/12/18 (32)

Job Completion



*Handwritten:* 2007/12/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

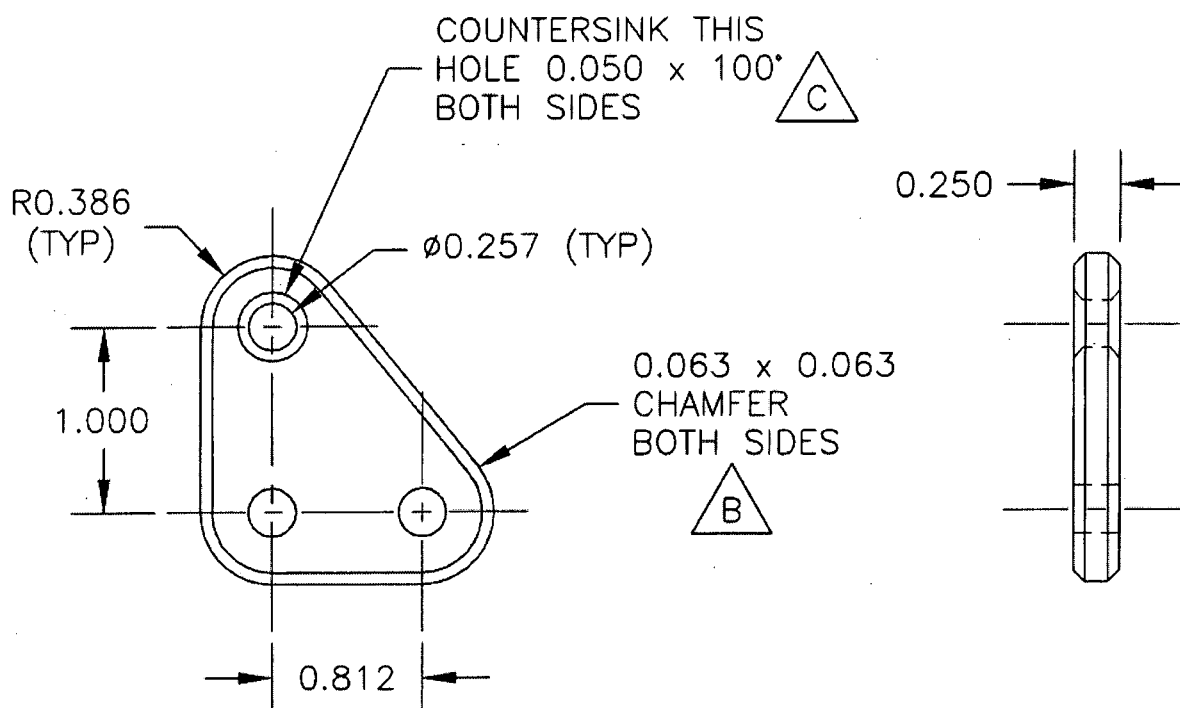
**NOTE:** Date & initial all entries





DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JA</i>	APPROVED <i>JA</i>	DRAWING NO. D2847	REV. C SHEET 1 OF 1
DATE 99.02.15		TITLE LUG	SCALE 1:1
A	98.11.04	NEW ISSUE	
B	99.01.07	ADD CHAMFER	
C	99.02.15	ADD COUNTERSINK	

RELEASED  
99.02.01 KE



MATERIAL: 6061-T6 OR 6061-T651 (QQ-A-225/8 OR QQ-A-200/8 OR QQ-A-250/11)

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 33594